



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2594-1
Job Sheet 168655



Part No: D2594-1

Job Qty: 350 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 11/26/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Rotorcraft Support Inc (CROTO01)

16425 Hart Street Van Nuys, CA, 91406 USA ph:(818) 997-7667 fx:(818) 997-1513.

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	350 Ea		11/24/17	0.00	0.00	Start Up Machining		
100	Hardinge	350 pcs		11/25/17	0.01	10.06	Hardinge		
110	QC	350 pcs		11/25/17	0.00	0.00	QC2		
120	QC	350 pcs		11/25/17	0.00	0.00	QC8		
130	HandFinish	350 pcs		11/25/17	0.00	0.81	HandFinish1		FR 17-12-21
135	Powdercoat	350 pcs		11/26/17	0.00	0.54	Powdercoat1		2667-12-21 28
150	QC	350 pcs		11/26/17	0.00	0.00	QC3		BR 14-12-28
160	Packaging	350 pcs		11/26/17	0.00	0.00	Packaging3	FP001	
170	QC21-SA	350 Ea		11/26/17	0.00	0.00	QC21		

Part Op 100 - 1-Make as per Dwg D2594-1 and Folio FA22.

Descriptions: 135 - START TIME: 0:50

160 - LOCATION : FP001

Job Allocation

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R0.625	18	22	0	0

Part Specifications

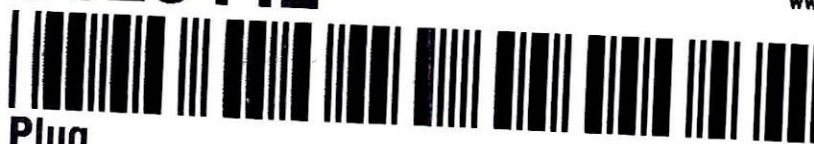
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055		
2	Plug	0.500inches ± 0.010	0.510 0.490		
3	Plug	0.625inches ± 0.010	0.635 0.615		
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428		
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088		
6	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		

M6061T6R0.625
SO21846

Plex 11/21/17 7:32 AM art.lacelle.linda

DART
AEROSPACE
S025442

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Plug

PART NO: D2594 - 1

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 12/20/17
Job No: 168655



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2594-1 Revision: Plug														
170	QC21-SA	S025442	168655	349 Ea	0	S025442	FP001	Bin	Stock	12/20/2017	Issue Container			
Operation Totals:		1		349	0									
Part Totals:		1		349	0									
Part Number: M6061T6R0.625 Revision: 6061-T6 Round Bar .625"														
100	Receive Ft	S025440	168655	0 ft	0		MAT005		Stock	12/20/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		349	0									

Plex 1/8/2018 8:08 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								